

slip 24/05

# Work Order ID 69564

Thursday, May 12, 2011 11:10:44 AM



Page 1

Item ID:	D3713-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Assembly				Stop	
Start Date:	5/12/2011	Start Qty: 1.00		Cust Item ID:		
Required Date:	5/17/2011	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date: 11-05-12	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3713	Rev B								
D3715	A								
100		0.00							
	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1- drill holes in both D3715-1 as per dwg D3715								
	2- deburr								
	3- assemble as per dwg D3713 and weld as per QSI004								
110		0.00							
	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1- cut mesh as per dwg D3743								
	2- weld mesh as per dwg D3713								

Pl 11.05.19

Pl 11.05.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69564**

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Item ID: D3713-042

Accept

Revision ID:

Item Name: Lid Assembly

Start Date: 5/12/2011 Start Qty: 1.00

Required Date: 5/17/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	<del>11-05-20</del> D. Moshko			1 (X)	0		
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00	11-05-20 SY 11-05-20 AA 11-05-20			1 (1x)	0		
140  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: 8:30 OVEN TEMPERATURE: 300° FINISH TIME: 9:00	0.00  0.00	11-5-24			1	0	11-5-24	

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

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Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1	0	10	5/20
160  HandFinish Hand Finishing	HandFinishing  Memo <i>m 117315.</i> 1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4 2-apply armor shield over label on lid only	0.00  0.00				1	0	11-5	24
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1	0	11	5/25

W/O:		WORK ORDER CHANGES						
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Required Date: 5/17/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: *G.A* 0.00

Packaging

Memo

*w/o 69563 (180)* 0.00

Packaging

190

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

Quality Control

*ES 11/05/25 10**11/5/2011*  
*MF*  
*11-05-25*

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, May 12, 2011 11:10:51 AM

Page 1

Work Order ID: 69564

Parent Item: D3713-042

Parent Item Name: Lid Assembly

Start Date: 5/12/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:EC IPP Rev:C  
add label DD 10.03.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-1

Manufactured

No

100

Each

21.0000

2

2



Spacer Bushing

Location

Loc Qty

Loc Code

WA005

21

60174

1

64899

20

D2329

Manufactured

No

100

Each

6.0000

1

1



Label Plate

Location

Loc Qty

Loc Code

WA006

6

40488

6

D2581

Manufactured

No

100

Each

38.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

38

68964

38

D3749-1

Manufactured

No

100

Each

3.0000

3

3



Hinge Half

Location

Loc Qty

Loc Code

WA005

3

57748

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, May 12, 2011 11:10:52 AM

Page 2

Work Order ID: 69564

Parent Item: D3713-042

Parent Item Name: Lid Assembly

Start Date: 5/12/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,259.992

31.022

32.67474



304 SQ Tube .75x.75x.065W



*11-05-18*

Location

Loc Qty

Loc Code

MAT018

1000

117598

1000

WA007

259.9928906

116267

162.707172

116763

97.2857186

M304EX0.75-16F

Purchased

No

110

sf

518.0152

17

17.89474



Expanded Metal Flat SS



*32.65 + 1 END BAR  
Scrap*

*11-05-19*

Location

Loc Qty

Loc Code

WA

518.0152

115012

114

117197

182.3016

117455

221.7136

D2258-300

Manufactured

No

160

Each

6.0000

1

1



Label



*11-05-24*

Location

Loc Qty

Loc Code

ST505

6

55718

6

*X1*

Thursday, May 12, 2011 11:10:52 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

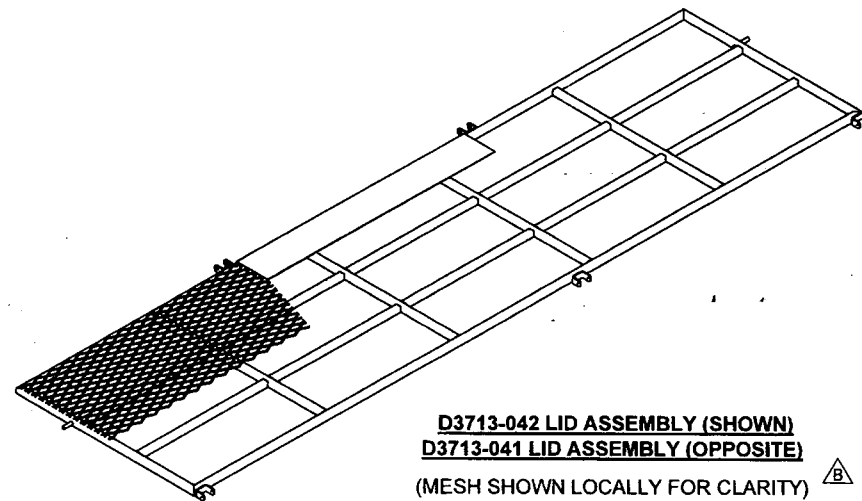
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69564

#### NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO. D3713	REV. B SHEET 1 OF 3
CHECKED	LE	TITLE LID ASSEMBLY	SCALE NTS
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DE APPR.	#		

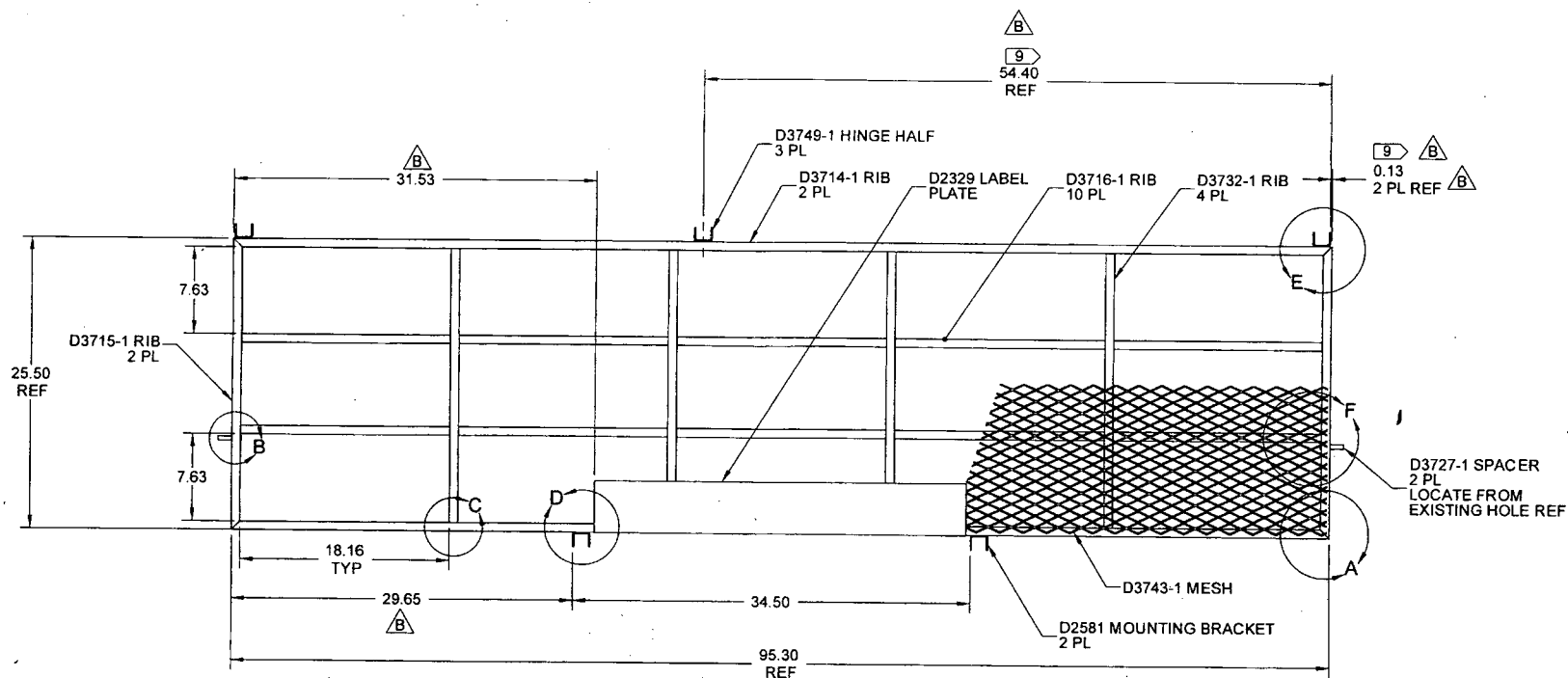
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**D3713-042 LID ASSEMBLY (SHOWN)**  
**D3713-041 LID ASSEMBLY (OPPOSITE)**  
 (MESH SHOWN LOCALLY FOR CLARITY)

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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 69564

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JP	D3713	SHEET 2 OF 3
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11-05-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

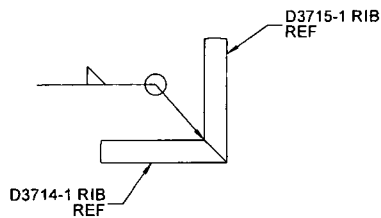
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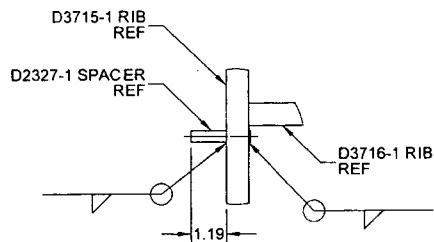
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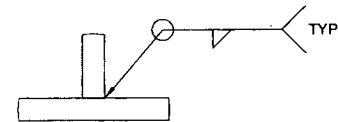




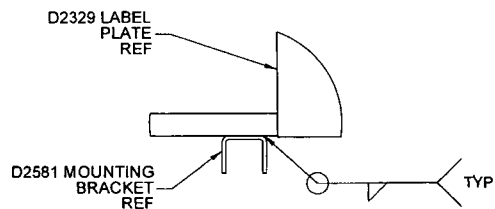
**DETAIL A: TYP CORNER WELDS**  
SCALE 4X  
(MESH NOT SHOWN FOR CLARITY)



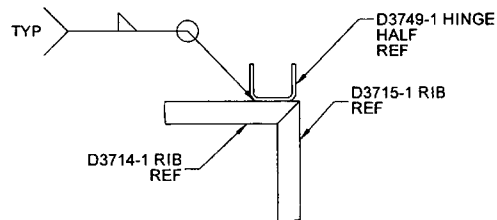
**DETAIL B**  
TYP BOTH ENDS  
SCALE 4X



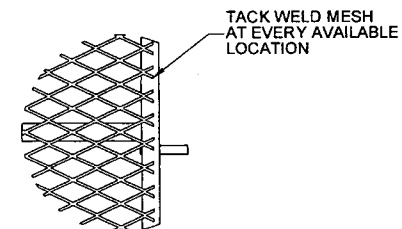
**DETAIL C**  
TYP  
SCALE 4X



**DETAIL D**  
SCALE 4X



**DETAIL E**  
SCALE 4X



**DETAIL F**  
SCALE 5X

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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u/069564

05.03.17.17P

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